

Work Order ID 128460

Friday, January 16, 2015 2:45:23 PM

128460

Page 1

Item ID: D3009-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cup

Start Date: 1/16/15

Start Qty: 30.00

30

Cust Item ID:

Required Date: 1/16/15

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: MCSDate: 15-01-20

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3009

Rev B

100

0.00

DAS

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA130 & DWG D3009

FOLIO REV: N/ADWG REV: B

2-DEBURR AS REQUIRED

30Ø

37

9-89

15.02.03

110

0.00

DAS

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

30Ø

37

9-89

15.02.03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Stop *NR2*

DAS
40
9-89

15/02/04

*****STOCK IN LARGE FAB*****

x 30 15-02-25 MAL

0.00

MCS 1502-27

mmf-

15-2-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 16, 2015 2:45:22 PM

Page 1

Work Order ID: 128460

128460

Parent Item: D3009-3

D3009-3

Parent Item Name: Cup

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A 07.12.18new issue EC
IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R1.000		Purchased		No		110	f	30.0000	0.0479	1.512633			
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M304R1 000

304 round bar 1.00

DAS

37

9.89

15.02.03

Location

Loc Qty

Loc Code

MAT029

30

m128005

30

1.5 ft.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

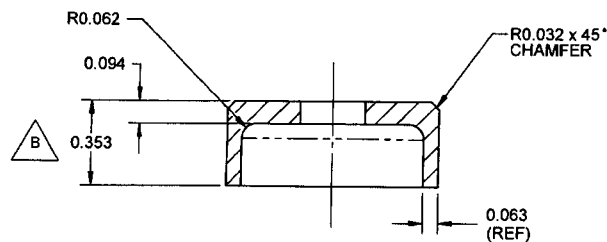
Work Order update only ☐

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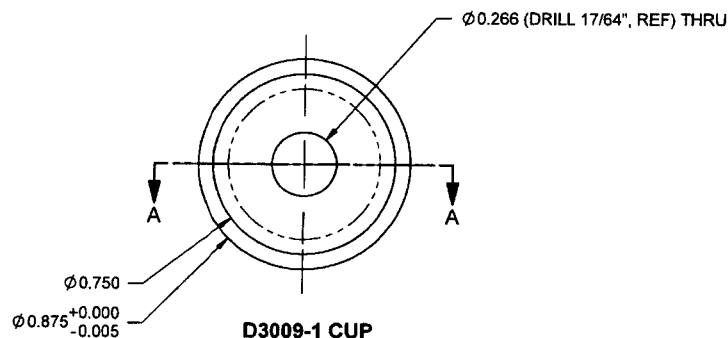
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SECTION A-A



D3009-1 CUP

NOTES:

- 1) MATERIAL: AISI 1018-1025 ROUND BAR
(REF DART SPEC M1018-R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

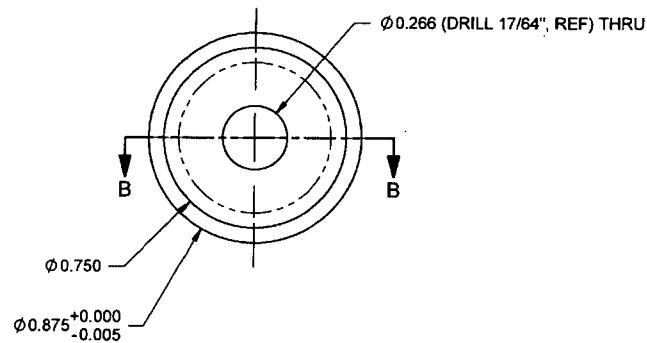
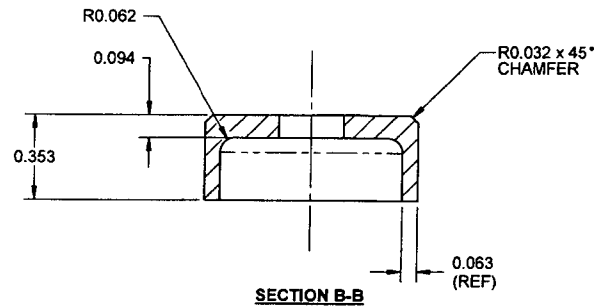
SHOW COPY
REF TO
UNCONTROLLED COPY
SUBJECT TO
WITHOUT NOTICE
WORK ORDER

NO. 128460-MCS

150120

RELEASED
88-01-07

B	REDRAW/REFORMAT DWG. D3009-1 MAT'L WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.363 (D7), Ø0.266 WAS Ø0.257 (C5), ADD D3009-3 (SHEET 2)	CP	07.12.12
A	NEW ISSUE	RF	01.03.23
REV.	DESCRIPTION	BY	DATE
DESIGN	gpi		
DRAWN	gpi		
CHECKED	gpi		
MFG. APPR.	gpi		
APPROVED	gpi		
DE APPR.	gpi		
DATE	07.12.12		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3009 TITLE CUP REV. B SHEET 1 OF 2 SCALE 2:1 COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D3009-3 CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART SPEC M304R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

RELEASE
03-01-07-10

DESIGN	gpi	DART AEROSPACE LTD	
DRAWN	gpi	HAWKESBURY, ONTARIO, CANADA	
CHECKED	gpi	DRAWING NO. D3009	REV. B
MFG. APPR.	gpi	SHEET 2 OF 2	
APPROVED	gpi	TITLE	SCALE
DE APPR.	gpi	CUP	2:1
DATE	07.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	